Work Order ID 72133

Tuesday, July 19, 2011 12:43:28 PM



Page 1

Item ID: Revision ID:	D3455-1			Accept			s	etup Star Stop	1 10 031101 0101	
Item Name: Start Date: Required Date Reference:	Spacer 7/19/2011 e: 7/25/2011	Start Qty: 40.00 Req'd Qty: 40.00	1 (ATI)) (Cust Item II Customer:	D:		Stut	'	
Approvals:	Process Pl	an:	Date:	7_/9 Tooling: SPC (Y/N):		te:	R	tun Star Stop		
Sequence ID/ Work Center	ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool # Plan Code	Accept Qty	Reject Qty	-	Insp. Stamp
Draw Nbr D3455	Re ^s	vision Nbr v A								
Hardinge CNC La		Hardinge CNC LATH Memo HARDHI ,□FOLIO		0.00 0.00 RN AS PER FOLIO FA583 & DV G REV: □2-DEBURR	√G D3455 AS REQUIRED		40)		
QC Quality Control		QC2- Inspect parts of	f machine FAI/FAIB	0.00	1819		40			·
120 QC Quality Control		QC8- Inspect parts - s Memo	second check	0.00	C. S. (હ	46			

W/O:			V	ORK ORDER CHANG	GES					
DATE	STEP	PRO	OCEDURE CH			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Ca	tegory:	_ NCF	l: Yes I	No DQ	A:	Date: _	
			Disposit	ion:	QA:	N/C Clo	sed:		Date:	
NCR:			WORK OR	DER NON-CONFORM	ANCE	(NCR)			
DATE	STEP	Description of NC			ction B		Verifi	cation	Approval	Approval
DAIL	SILI	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Sect	ion C	Chief Eng	QC Inspector
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Packaging

Packaging



Page 2

Tuesday, July 19, 2011 12:43:28 PM Item ID: D3455-1 Accept Setup Start **Revision ID:** Stop Item Name: Spacer 7/19/2011 **Start Otv: 40.00 Start Date: Cust Item ID: Required Date: 7/25/2011** Rea'd Otv: 40.00 **Customer:** Reference: Run Start Approvals: Process Plan: Date: Tooling: Date: Stop Date: OC: **SPC (Y/N):** Date: Sequence ID/ Operation Accept Reject Set Up/ Tool ID Tool # Plan Reject Insp. Work Center ID Description Number Stamp Code **Qty Run Hours Qty** 130 0.00 Small Fab Small Fab Memo Small Fab Deburr if negessary. QC5- Inspect part completeness to step on V 140 OC Memo Quality Control Identify as per dwg & Stock Location:

0.00

0.00

Memo

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W/O:			WC	ORK ORDER CHANG	GES					
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	/ 1	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No):	PAR #:	Fault Cate	gory:	NCR: Y	es N	DQA	\:	_ Date: _	
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NCR:		1	WORK ORD	ER NON-CONFORM	ANCE (N	ICR)				
DATE	STEP	Description of NC	Corrective Action Section				Verific	ation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Si	gn & late	Section		Chief Eng	QC Inspector
	 									
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Work Order ID 72133

Tuesday, July 19, 2011 12:43:28 PM



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Item ID:

D3455-1

Accept

Setup Start



Revision ID:

Start Date:

Item Name: Spacer

Required Date: 7/25/2011

QC:

7/19/2011

Start Qty: 40.00

Req'd Qty: 40.00

Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Operation

Description

Date:

QC21- Final Inspection - Work Order Release

Date: SPC (Y/N):

Tooling:

Date:

Date:

Start

Run

Stop

Stop

Sequence ID/ Work Center ID

160

Quality Control

Memo

0.00

0.00

Set Up/

Run Hours

Tool ID

Tool # Plan

Accept Code Qty

Reject Qty

Reject Insp. Number Stamp

W/O:			W	ORK ORDER CHANG	ES					_
DATE	STEP	PRO	CEDURE CH	ANGE	В	у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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NCR:		V	WORK ORE	DER NON-CONFORM	ANCE (I	ICR)				
DATE	STEP	Description of NC	Description of NC Corrective Action				Verific	ation	Approval	Approval
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Picklist Print

Tuesday, July 19, 2011 12:43:34 PM

Work Order ID: 72133

Parent Item:

D3455-1

Parent Item Name: Spacer



Start Date: 7/19/2011

Required Date: 7/25/2011

Start Qty: 40.00

Required Qty: 40.00

Comments:

IPP REV. A

05.11.17

NEW ISSUE

EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR 1.000		Purchased	No		100	f	28.2680	0.022	0.926316	,	15/	<u></u>

Delrin Round Bar 1"

oc Code

B ft

Page 1

- 4	Johago								بعب ع
W/O:		44	WC	ORK ORDER CHANGE	S		*		
DATE	STEP	PRO	OCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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									1.
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	_ Date: _	
	Re	esolution:	Dispositio	n:	QA: N/C Cld	sed:		Date: _	
NCR:		,	WORK ORD	ER NON-CONFORMAN	NCE (NCR)		* 1 12 * - 1	
DATE	STEP	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval
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DART AEROSPACE LTD	Work Order:	72/33
Description: Spacer	Part Number:	D3455-1
Inspection Dwa: D3455 Rev: A		Page 1 of 1

	FIRS	ST ARTICLE II	NSPECTI	ON CHE	ECKLIST		
		X First Arti	cle	Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Con	nments
Ø0.453	+0.005/-0.000	.4535			57-8		
Ø1.00	+0.010/-0.001	1.004	/				
0.065	+/-0.010	.625					
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Measured by:	11/8/19	Audited by:	-		Prototype A		N/A
" Date:	11/8/9	Date:	a. L	- ta	,	Date:	N/A
Rev Date	Change					Revised by	Approved
A 06.07.11	New Issue			•		⟨J/JLM ८४	H K

Dart	Aeros	space	Ltd
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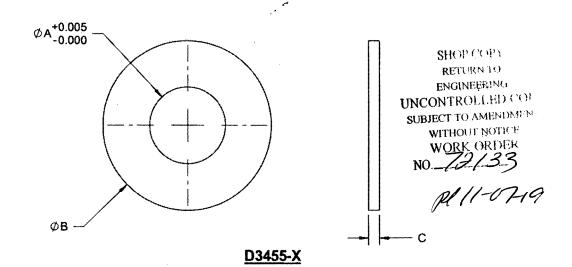
	Johaco								
W/O:			WC	ORK ORDER CHANG	ES	·			
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:	Fault Cate	gory:	NCR: Yes	No DQA	\ :	_ Date: _	
	Re	esolution:	Disposition	n:	QA: N/C Cld	sed:		Date:	
NCR:			WORK ORD	ER NON-CONFORMA	•	•			
DATE	CTED	Description of NC		on B	Verific		Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector

NOTE: Date & initial all entries



DESIGI R	-	DRAWN BY		OSPACE LTD ONTARIO, CANADA
CHECK	ED#	APPROVED	DRAWING NO. D3455	REV. A SHEET 1 OF 1
DATE	***************************************		TITLE	SCALE
	05.0	9.02	SPACER	2:1
Α	0	5.09.02	NEW ISSUE	

RELEASED 05.12.09



1) SPECIFICATION: D3455-X SPACER

DASH No.

WHERE 'X' IS THE SIZE PER THE FOLLOWING TABLE:

DASH No.	A (in)	B (in)	C (in)		
-1	0.453	1.00	0.065		
-3	0.386	1.00	0.050		

NOTES:

- 1) MATERIAL: DELRIN ROUND BAR (REF. DART SPEC. M-DELRIN-R)
- 2) FINISH: NONE
 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) ALL DIMENSIONS ARE IN INCHES
 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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W/O:			WO	RK ORDER CHANC	GES			<u></u> -		
DATE	STEP	PRO	CEDURE CHAI	EDURE CHANGE		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector	
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		i								
Part No:		PAR #:	PAR #: Fault Category:			NCR: Yes No DQA: Date:				
	Re	solution:	tion: Disposition:			QA: N/C Closed:			Date:	
NCR:			VORK ORDE	R NON-CONFORM	ANCE (NC	R)				
DATE	STEP	Description of NC	Corrective Action Section			Verifi	cation	Approval	Approval	
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